

Work Order ID 96118

96118

Page 1

January-23-13 8:58:19 AM

Item ID: D412-761-051

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Armrest, LH

Start Date: 1/21/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/15/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: W Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|--------------|---|
| JIN D412-761 | E |
|--------------|---|

100

0.00

Smb

100

DOCUMENT CONTROL

0.00

DC

Memo

Document Control

Photocopy bluefile & type labels per PPPD412-761-051

CHG003

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

Smb

13.2 19

LAB only

13-2-12 (2)

06/06/13

2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|---|--|

Work Order ID 96118

96118

Page 2

January-23-13 8:58:19 AM

Item ID: D412-761-051 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Armrest, LH
 Start Date: 1/21/13 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 2/15/13 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Packaging | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPPD412-761-051 | | | | | | | | |
| | Location: _____ | | | | | | | | |
| | PPP Rev: _____ | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

DAS
06
9-8

13/2/20 8

13/2/20 48

113-0220

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| Landing Gear | General | Other |
|---|---|--|
| <input type="checkbox"/> Bending | <input type="checkbox"/> Bend | <input type="checkbox"/> Grain |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> BOM/Route | <input type="checkbox"/> Hardware |
| <input type="checkbox"/> Cracks | <input type="checkbox"/> Broken/Damaged | <input type="checkbox"/> Inspection Incomplete |
| <input type="checkbox"/> Crushed/Crimped | <input type="checkbox"/> Burrs | <input type="checkbox"/> Instructions Incomplete/Unclear |
| <input type="checkbox"/> Cuffs | <input type="checkbox"/> Contamination | <input type="checkbox"/> Maintenance |
| <input type="checkbox"/> Heat Treat | <input type="checkbox"/> Countersink | <input type="checkbox"/> Mislabeled |
| <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Misread |
| <input type="checkbox"/> Ripples in Bend | <input type="checkbox"/> Drill Holes | <input type="checkbox"/> Offset |
| <input type="checkbox"/> Torque Waves in Extrusion | <input type="checkbox"/> Drawing | <input type="checkbox"/> Out of Calibration |
| <input type="checkbox"/> Turning Sequence | <input type="checkbox"/> Finish | <input type="checkbox"/> Out of Sequence |
| <input type="checkbox"/> Wave/Twist in Tube | <input type="checkbox"/> Folio | <input type="checkbox"/> Outside Dimensions |
| | | <input type="checkbox"/> Ovalized |
| | | <input type="checkbox"/> Over/Under tolerance |
| | | <input type="checkbox"/> Part Incorrect |
| | | <input type="checkbox"/> Part Lost/Missing |
| | | <input type="checkbox"/> Part Moved |
| | | <input type="checkbox"/> Positioned Wrong |
| | | <input type="checkbox"/> Power Loss/Surge |
| | | <input type="checkbox"/> Pressure/Forced |
| | | <input type="checkbox"/> Temperature/Cure |
| | | <input type="checkbox"/> Weld |
| | | <input type="checkbox"/> Wrong Stock Pulled |
| | | <input type="checkbox"/> Other |

January-23-13 8:58:18 AM

Required Qty: 2.00

Comments: IPP Rev:A new issue DD 10.05.18 verf:EC IPP REV:B 12.03.06 AS PER ECN12-535 DD VERF:EC IPP Rev:C 13.01.15 as per ECN13-511 DD Verf:JLM

[illegible]

100

—

200

—

15

2.

2

6/65
28

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | |
|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION <div style="display: flex; justify-content: space-around;"> <div> <input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update </div> <div> <input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab </div> <div> <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite </div> <div> <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier </div> <div> <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other </div> </div> |
|--|--|

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|---|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions |
|---|---|---|

| | |
|--|---|
| <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|---|

Picklist Print

January-23-13 8:58:18 AM

Page 2

Work Order ID: 96118

Parent Item: D412-761-051

Parent Item Name: Armrest, LH

Start Date: 1/21/13

Required Date: 2/15/13

Start Qty: 2.00

Required Qty: 2.00

D3694-041
MOUNTING PLATE

Manufactured No

110 Each 4.0000

1

2

65

Location

Loc Qty

Loc Code

ST248A

4

85571

1

87896

3

87896

D3695-041
Slider Assembly

Manufactured No

110 Each 1.0000

1

2

96/22/13

Location

Loc Qty

Loc Code

ST247

1

87898

1

87898 10

D4097-041
Armrest Assembly

Manufactured No

110 Each 4.0000

1

2

65

Location

Loc Qty

Loc Code

ST187

4

87949

4

87949

MS21071L3
ANCHOR NUT

Purchased No

110 Each 171.0000

3

6

65

Location

Loc Qty

Loc Code

ST317

171

102587

21

123301

100

124291

50

102587

MS21075L3
Nutplate

Purchased No

110 Each 43.0000

8

16

11/23/2013

Location

Loc Qty

Loc Code

ST318

43

123832

43

MS24665-302
Cotter Pin

Purchased No

110 Each 191.0000

1

2

1/13/2/13

Location

Loc Qty

Loc Code

GA

191

120521

191

120521

January-23-13 8:58:18 AM

Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
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| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data <input type="checkbox"/> | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | |

FAULT CATEGORY

| | | |
|---|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions |
| | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge |
| | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

Picklist Print

January-23-13 8:58:18 AM

Page 3

Work Order ID: 96118

Parent Item: D412-761-051

Parent Item Name: Armrest, LH

Start Date: 1/21/13

Required Date: 2/15/13

Start Qty: 2.00

Required Qty: 2.00

NAS1515H61
WASHER

Purchased

No

110

Each

31.0000

4

13/2/13
S
C

Sm B 2

Location

Loc Qty

Loc Code

ST298

31

18918

31

18918

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data <input type="checkbox"/> | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | |

FAULT CATEGORY

| | | |
|---|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|---|---|--|

5.0 PARTS LIST, MODIFIED FULL VERTICAL REFERENCE DOOR KITS

| QTY -011 | QTY -011A | QTY -041 | QTY -041A | QTY -043 | QTY -045 | QTY -047 | QTY -049 | QTY -051 | QTY -141 | PART NUMBER | DESCRIPTION |
|-------------|--------------|-------------|--------------|-------------|-------------|-------------|-------------|-------------|-------------|---|---|
| X | | | | | | | | | | D412-761-011 | FULL VERTICAL REFERENCE DOOR, LH |
| | X | | | | | | | | | D412-761-011A | FULL VERTICAL REFERENCE DOOR, LH |
| 1 | | X | | | | | | | | D412-761-041 | FULL VERTICAL REFERENCE DOOR KIT, LH |
| | 1 | | X | | | | | | | D412-761-041A | FULL VERTICAL REFERENCE DOOR KIT, LH |
| | | | | X | 1 | | | | | D412-761-043 | MODIFIED LATCH MECHANISM KIT, LH |
| | | 1 | 1 | | X | | | | | D412-761-045 | LARGE BUBBLE WINDOW KIT, LH |
| | | 1 | 1 | | | X | | | | D412-761-047 | DOOR MOUNTED INSTRUMENT PANEL KIT, LH |
| | | 1 | | | | | X | | | D412-761-049 | ARMREST KIT, LH |
| | | | 1 | | | | | X | | D412-761-051 | ARMREST KIT, LH |
| 1 | 1 | | | | | | | | X | D412-761-141 | VENT KIT |
| 1 | 1 | | | | | | | | | 204-030-853-125 OR 204-030-853-137 OR 204-030-853-155 OR 204-030-853-153 | BELL 204, 205, 210, 412 OEM DOOR |

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6.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD KITS

| QTY -041 | QTY -041A | QTY -043 | QTY -045 | QTY -047 | QTY -049 | QTY -051 | QTY -141 | PART NUMBER | DESCRIPTION |
|-------------|--------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|---------------------------------------|
| | | | | | | | | D412-761-011 | FULL VERTICAL REFERENCE DOOR, LH |
| | | | | | | | | D412-761-011A | FULL VERTICAL REFERENCE DOOR, LH |
| X | | | | | | | | D412-761-041 | FULL VERTICAL REFERENCE DOOR KIT, LH |
| | X | | | | | | | D412-761-041A | FULL VERTICAL REFERENCE DOOR KIT, LH |
| | | X | 1 | | | | | D412-761-043 | MODIFIED LATCH MECHANISM KIT, LH |
| 1 | 1 | | X | | | | | D412-761-045 | LARGE BUBBLE WINDOW KIT, LH |
| 1 | 1 | | | X | | | | D412-761-047 | DOOR MOUNTED INSTRUMENT PANEL KIT, LH |
| 1 | | | | | X | | | D412-761-049 | ARMREST KIT, LH |
| | 1 | | | | | X | | D412-761-051 | ARMREST KIT, LH |
| | | | | | | | X | D412-761-141 | VENT KIT |
| | | 1 | | | | | | D3589-041 | LATCH ASSEMBLY |
| | | 1 | | | | | | D3589-047 | FORWARD GUIDE |
| | | 1 | | | | | | D3589-049 | AFT GUIDE |
| | | 2 | | | | | | MS16997-24 | SCREW |
| | | 2 | | | | | | MS21042L06 | NUT |
| | | 2 | | | | | | NAS1149DN632J | WASHER (OR AN960JD6L) |
| | | 1 | | | | | | D3676-1 | LARGE BUBBLE WINDOW |
| | | 1 | | | | | | D3678-1 | PLACARD |
| | | 1 | | | | | | D3678-3 | PLACARD |
| | | 1 | | | | | | D3700-1 | INBOARD WINDOW DOUBLER |
| | | 1 | | | | | | D3700-3 | OUTBOARD WINDOW DOUBLER |
| | | 1 | | | | | | D3701-1 | FLOOR DOUBLER |
| | | 1 | | | | | | D3702-1 | FORWARD DOUBLER |
| | | 1 | | | | | | D3703-1 | AFT DOUBLER |
| | | 1 | | | | | | D3703-3 | AFT CORNER DOUBLER |
| | | 1 | | | | | | D3703-5 | AFT CAP |
| | | 1 | | | | | | D3704-1 | ESCUTCHEON |
| | | 1 | | | | | | D3704-3 | ESCUTCHEON |
| | | 1 | | | | | | D3708-1 | ANGLE |
| | | 1 | | | | | | D3708-3 | ANGLE |
| | | 1 | | | | | | D3709-1 | ANGLE |
| | | 1 | | | | | | D3709-3 | ANGLE |
| | | 1 | | | | | | D3802-1-135 | SEAL |
| | | 1 | | | | | | DT9458 | CUTTING TEMPLATE |
| | | 26 | | | | | | AN3-7A | BOLT |
| | | 26 | | | | | | MS21042L3 | NUT |
| | | 1 | | | | | | MS24694-C5 | SCREW (OR MS24694-S5) |
| | | 1 | | | | | | MS24694-C13 | SCREW (OR MS24694-S13) |
| | | 1 | | | | | | NAS43DD3-24 | SPACER |
| | | 52 | | | | | | NAS1149D0363J | WASHER (OR AN960JD10) |

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| QTY -041 | QTY -041A | QTY -043 | QTY -045 | QTY -047 | QTY -049 | QTY -051 | QTY -141 | PART NUMBER | DESCRIPTION |
|-------------|--------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|---|
| | | | | 1 | | | | D3705-041 | INSTRUMENT PANEL ASSEMBLY |
| | | | | 1 | | | | D3705-043 | * INSTRUMENT PANEL WELDMENT |
| | | | | 1 | | | | D3335-1 | * SPRING |
| | | | | 1 | | | | D3705-5 | * ACCESS PANEL |
| | | | | 1 | | | | D3706-041 | * LOCK BRACKET ASSEMBLY |
| | | | | 1 | | | | D3706-5 | * PIN |
| | | | | 2 | | | | D3707-3 | * MOUNTING LUG |
| | | | | 2 | | | | AN3-3A | * BOLT |
| | | | | 4 | | | | AN526C1032R6 | * SCREW |
| | | | | 1 | | | | MS171498 | * SPRING SLOTTED PIN |
| | | | | 4 | | | | MS24693-C272 | * SCREW (OR MS24693-S272) |
| | | | | 2 | | | | NAS1149D0332J | * WASHER (OR AN960JD10L) |
| | | | | 1 | | | | NAS1149D0563J | * WASHER (OR AN960JD516) |
| | | | | 1 | | | | D3705-7 | FACE PLATE (MINIMUM REQUIRED INSTRUMENTS FOR 204, 205, 210, AND EAGLE SINGLE MODELS) |
| | | | | 1 | | | | D3705-9 | FACE PLATE (MINIMUM REQUIRED AND OPTIONAL INSTRUMENTS FOR 204, 205, 210, AND EAGLE SINGLE MODELS) |
| | | | | 1 | | | | D3705-11 | FACE PLATE (FOR 212, 214, 412, MODELS) |
| | | | | 2 | | | | D3707-1 | MOUNTING LUG |
| | | | | 1 | | | | D3790-1 | INDEXING BLOCK |
| | | | | 1 | | | | D3867-1 | CONNECTOR PLATE |
| | | | | 2 | | | | D4758-1 | BLANKING PLATE |
| | | | | 3 | | | | D4758-3 | BLANKING PLATE |
| | | | | 4 | | | | AN3-4A | BOLT |
| | | | | 6 | | | | AN526C1032R6 | SCREW |
| | | | | 2 | | | | AN743-12 | BRACKET |
| | | | | 6 | | | | AN960JD10L | WASHER |
| | | | | 6 | | | | MS21075L3 | NUTPLATE (OR MS21073-3) |
| | | | | 4 | | | | MS24693-C272 | SCREW (OR MS24693-S272) |
| | | | | 1 | | | | MS27039-1-17 | SCREW |
| | | | | 1 | | | | MS27039-1-27 | SCREW |
| | | | | 4 | | | | MS21042L3 | NUT |
| | | | | 2 | | | | MS21919WDG8 | CLAMP |
| | | | | 4 | | | | NAS1149D0332J | WASHER (OR AN960JD10L) |
| | | | | | 1 | 1 | | D3694-041 | MOUNTING PLATE ASSEMBLY |
| | | | | | 1 | 1 | | D3694-1 | * KEYWAY |
| | | | | | 1 | 1 | | D3694-3 | * PROTECTIVE PLATE |
| | | | | | 1 | 1 | | D3694-5 | * MOUNTING PLATE |
| | | | | | 1 | 1 | | AN526C1032R8 | * SCREW |
| | | | | | 4 | 4 | | MS21042L3 | * NUT |
| | | | | | 2 | 2 | | MS21209F1-20 | * HELI-COIL, SCREW LOCKING (RED) |
| | | | | | 1 | 1 | | MS24693-C271 | * SCREW (OR MS24693-S271) |
| | | | | | 4 | 4 | | MS24693-C273 | * SCREW (OR MS24693-S273) |
| | | | | | 5 | 5 | | NAS1149D0363J | * WASHER (OR AN960JD10) |
| | | | | | 1 | 1 | | D3695-041 | SLIDER ASSEMBLY |
| | | | | | 1 | 1 | | D3695-1 | * SLIDER |
| | | | | | 1 | 1 | | D3695-3 | * STOPPER |
| | | | | | 1 | 1 | | MS21209F6-25 | * HELI-COIL, SCREW LOCKING (RED) |
| | | | | | 4 | 4 | | MS21209F1-20 | * HELI-COIL, SCREW LOCKING (RED) |
| | | | | | 4 | 4 | | MS24693-C276 | * SCREW (OR MS24693-S276) |
| | | | | | 1 | 1 | | D3801-1 | * HAND RETRACTABLE SPRING PLUNGER |

*DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

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| QTY -041 | QTY -041A | QTY -043 | QTY -045 | QTY -047 | QTY -049 | QTY -051 | QTY -141 | PART NUMBER | DESCRIPTION |
|-------------|--------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|---------------------------------------|
| | | | | | 1 | | | D3780-041 | ARMREST ASSEMBLY |
| | | | | | 1 | | | D3696-041 | * ARM ASSEMBLY |
| | | | | | 1 | | | D3696-1 | ** ARM |
| | | | | | 1 | | | D3801-3 | ** HAND RETRACTABLE SPRING PLUNGER |
| | | | | | 1 | | | D3781-041 | * LATERAL CUSHION ASSEMBLY |
| | | | | | 1 | | | D3781-043 | * ARMREST CUSHION ASSEMBLY |
| | | | | | 1 | | | D3785-3 | * BRACKET |
| | | | | | 1 | | | D3977-1 | * BOLT |
| | | | | | 1 | | | D3978-1 | * NUT (CASTELLATED) |
| | | | | | 1 | | | D3979-1 | * WASHER (SQUARE HOLE) |
| | | | | | 2 | | | AN970-6 | * WASHER |
| | | | | | 1 | | | MS24665-302 | * COTTER PIN |
| | | | | | 2 | | | MS21042L3 | * NUT |
| | | | | | 2 | | | MS24693-C272 | * SCREW |
| | | | | | 2 | | | MS24693-C277 | * SCREW |
| | | | | | 1 | | | NAS1149D0663J | * WASHER (OR AN960JD616) |
| | | | | | 11 | | | AN3-6A | BOLT |
| | | | | | 1 | | | AN6-26 | BOLT |
| | | | | | 1 | | | AN320-6 | CASTELLATED NUT |
| | | | | | 11 | | | NAS1149D0363J | WASHER (OR AN960JD10) |
| | | | | | 1 | | | NAS1149D0616J | WASHER (OR AN960JD616L) |
| | | | | | 2 | | | NAS1515H6L | WASHER |
| | | | | | 1 | | | MS24665-302 | COTTER PIN |
| | | | | | 3 | | | MS21071L3 | ANCHORNUT |
| | | | | | 8 | | | MS21075L3 | NUTPLATE |
| | | | | | | 1 | | D4097-041 | ARMREST ASSEMBLY |
| | | | | | | 1 | | D3696-041 | * ARM ASSEMBLY |
| | | | | | | 1 | | D3696-1 | ** ARM |
| | | | | | | 1 | | D3801-3 | ** HAND RETRACTABLE SPRING PLUNGER |
| | | | | | | 1 | | D4098-041 | * CUSHION ASSEMBLY |
| | | | | | | 1 | | D4099-1 | * BRACKET |
| | | | | | | 3 | | MS21042L3 | * NUT |
| | | | | | | 5 | | MS24693-C273 | * SCREW |
| | | | | | | 3 | | MS24693-C277 | * SCREW |
| | | | | | | 1 | | NAS1149D0332J | * WASHER |
| | | | | | | 11 | | AN3-6A | BOLT |
| | | | | | | 1 | | AN6-26 | BOLT |
| | | | | | | 1 | | AN320-6 | CASTELLATED NUT |
| | | | | | | 11 | | NAS1149D0363J | WASHER (OR AN960JD10) |
| | | | | | | 1 | | NAS1149D0616J | WASHER (OR AN960JD616L) |
| | | | | | | 2 | | NAS1515H6L | WASHER |
| | | | | | | 1 | | MS24665-302 | COTTER PIN |
| | | | | | | 3 | | MS21071L3 | ANCHORNUT |
| | | | | | | 8 | | MS21075L3 | NUTPLATE |
| | | | | | | | 4 | D3932-1 | SNAP VENT |

* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE
** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE